

Date: Thursday, 23/04/2009 1:38:54 PM
 User: Julie Dawson

Process Sheet

| | | | |
|----------------------------------|--|-------------------------|----------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : 350 SKIDTUBE ASSEMBLY LH |
| Job Number | : 47403 | | |
| Estimate Number | : 10266 | | |
| P.O. Number | : | Part Number | : D350636013 |
| This Issue | : 23/04/2009 | S.O. No. | : |
| Prsht Rev. | : NC | Drawing Number | : D2750 REV F |
| First Issue | : / / | Project Number | : N/A |
| Previous Run | : 46794 | Drawing Revision | : F |
| | Type : SKIDTUBES | Material | : |
| Written By | : | Due Date | : 08/05/2009 |
| Checked & Approved By | : <u>JUD 09-04-23</u> | Qty: | 1 |
| Comment | : Est Rev:H 02.09.25 Rearranged procedure steps KJ est rev I 06.03.30 Per rev. D dwg EC Est Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC Est Rev:K 08-09-23 revF as per dwg DD verified by:ec Est Rev:L 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010 DD verified by:EC | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



HJ for JUD 09/05/11



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-013 CHG 004

5 09/05/11

| | | |
|-----|------------|----------------|
| 2.0 | D26003BENT | Extrusion Bent |
|-----|------------|----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

042133

① 14 9-4-24

| | | |
|-----|-------|-----|
| 3.0 | D2744 | Cap |
|-----|-------|-----|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch

044892 BE 9-4-24

| | | |
|-----|-------------|-----------------------|
| 4.0 | SKIDTUBES 1 | SKIDTUBESS RESOURCE 1 |
|-----|-------------|-----------------------|



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 6 (D2750-3 details).Drill using drill Jig DT8150 & DT8864 .

M 9-4-24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47403

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750.

4-Drill pilot holes for the blade fitting bolt holes using DT8983. Open to 0.500".

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting.

6-Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.297"

8-Open up holes of Detail S to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *M110972 BE 07/04/24*

12-Grind welds flush as per Dwg D2750

13- scribe batch #.

W 9-4-24

AWM 9-4-24

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

5 07/04/24

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 07/04/24

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pm 09-04-27

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11 9-4-27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47403

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch: B47291

PM 09-04-270

10.0

D34901

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: B40772

BE 09/04/28

11.0

D34905

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: B43015

BE 09/04/28

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch: B45555

BE 09/04/28

13.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes section AW-AW 0.500" (4 per side) as per dwg D2750

2- Open holes section AV-AV 0.3125" (4 per side)

3-Open up holes of Detail T and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section AW-AW, AV-AV, T and ground handling. (welding instructions on sheet 10)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch: m111081

exp. date: 10-01-20

PM 09-04-270

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47403

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 10)

A/R Aluminum Rod batch: *m110972 BE 09/04/28*

8-Grind welds flush as per Dwg D2750 *Pm' / BE 09-04-29 0*

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750 *> Pm' 09-04-29 0*

10-Deburr holes

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/04/30 (X)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/30 (X)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

el

09-05-11

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

m111472

FL 09/05/11

(1)

(P10) ->

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

09-05-14

(X1)

19.0

ALS41032225

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Insert

Batch: *11110768*

el

09-05-14

(X1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|---|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 09/05/11 | 17.0 | start time: 1:30 Temp. : 320° Finish time: 2:00 | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47403

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
1-Install inserts as per dwg D2750

JL

09-05-14

(X)

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Bushing
Batch: 1346695

JL

22.0

D37911

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearplate
Batch: 1347536

JL

23.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearshoe
Batch: 1347537

JL

24.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearshoe
Batch: 1347211

JL

25.0

D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Gasket
Batch: 1347721

JL

26.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Gasket
Batch: 1347440

JL

09-05-15

(X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47403

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D353525

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B47204

JH

28.0

D353625

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B47526

JH

29.0

D35371

Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch: B47530

JH

30.0

D36311

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: B47437

JH

31.0

D3488041

Blade Fitting Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B44530

JH

32.0

NAS1611010

O-RING



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

O-RING

NAS1611-010 batch: _____

*

(or MS28775-010) batch: _____

JH

09-05-14 (V)

(PTO) =>

33.0

D34921

Plug



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Plug

batch: B47472

JH

09-05-14

(V)

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|--|----|----------|-----|-------------------------------------|--------------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 09-05-14 | 32.0 | Replace "O" rings with 02594-3 / B29908 NAS1611-010 | JH | 09-05-14 | x8 | | <i>[Signature]</i> 09/05/14 |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47403

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

NAS1611005

O-RING



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

O-RING

M106099

JH

35.0

D34925

Plug



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Plug

batch: B346993

JH

36.0

AN3C5A

Bolt



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Bolt

Batch: M111707

JH

37.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M1110372

JH

38.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M1110865

JH

39.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M1110105

JH

40.0

AN960C10L

washer



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

washer

Batch: M111668

JH

09-05-15

①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number: 47403

Part Number: D350636013

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
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|------|------------|--------|
| 41.0 | AN960C816L | WASHER |
|------|------------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Batch: M110372

Handwritten signature

| | | |
|------|----------|-----|
| 42.0 | MS210436 | NUT |
|------|----------|-----|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M110584

Handwritten signature

| | | |
|------|-----------|-----|
| 43.0 | MS21083C8 | NUT |
|------|-----------|-----|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M111637

Handwritten signature

| | | |
|------|------------|--------|
| 44.0 | NAS1515H3L | WASHER |
|------|------------|--------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: M110806

Handwritten signature

| | | |
|------|-----------------|----------------------------|
| 45.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|------|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

✓ 1-Inspect for Foreign Objects

X 2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M111081

EXP DATE: 10/20

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: M101223

✓ 5-Coat all exposed fasteners with "LPS Procyon" batch: M104251 *Handwritten signature* 09-05-15 *Handwritten initials*

| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47403

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/05/15 (X)

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

48.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: ~~345320~~

345320

9/5/19

49.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M111424

9/5/19

50.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M111637

9/5/19

51.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M110348

*****apply antiseize prior to packaging*****

Batch: M110658

9/5/19

52.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M108961

9/5/19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47403

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

53.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: 44902

9/5/19

SP

54.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

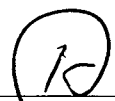
*****ensure antiseize is on AN8C21A bolts*****

809/05/19

55.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-013

Per G 9/5/20

SV

56.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-20

B47403

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

| QTY -041 | QTY -042 | QTY -043 | QTY -044 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|---------------|--|
| X | | | | D2750-041 | 350 SKIDTUBE ASSEMBLY, LH |
| | X | | | D2750-042 | 350 SKIDTUBE ASSEMBLY, RH |
| | | X | | D2750-043 | 350 SKIDTUBE ASSEMBLY, LH |
| | | | X | D2750-044 | 350 SKIDTUBE ASSEMBLY, RH |
| 1 | 1 | 1 | 1 | D2739 | WEB |
| 8 | 8 | 8 | 8 | D2743 | SPACER |
| 1 | 1 | 1 | 1 | D2744 | CAP |
| 8 | 8 | 8 | 8 | D2745 | BUSHING |
| 1 | | | | D2750-1 | SKIDTUBE WELDMENT, LH |
| | 1 | | | D2750-2 | SKIDTUBE WELDMENT, RH |
| | | 1 | | D2750-3 | SKIDTUBE WELDMENT, LH |
| | | | 1 | D2750-4 | SKIDTUBE WELDMENT, RH |
| 1 | | 1 | | D3488-041 | BLADE FITTING, LH |
| | 1 | | 1 | D3488-042 | BLADE FITTING, RH |
| 4 | 4 | 4 | 4 | D3490-1 | SPACER |
| 4 | 4 | | | D3490-3 | SPACER |
| | | 4 | 4 | D3490-5 | SPACER |
| 8 | 8 | 8 | 8 | D3492-041 | PLUG ASSEMBLY |
| 8 | 8 | | | D3492-043 | PLUG ASSEMBLY |
| | | 8 | 8 | D3492-045 | PLUG ASSEMBLY |
| 1 | 1 | 1 | 1 | D3535-25 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3536-25 | GASKET |
| 3 | 3 | 3 | 3 | D3537-1 | WEARPAD |
| 8 | 8 | 8 | 8 | D3631-1 | WASHER |
| 1 | 1 | 1 | 1 | D3791-1 | WEARPLATE |
| 1 | 1 | 1 | 1 | D3793-1 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3793-3 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3794-1 | GASKET |
| 1 | 1 | 1 | 1 | D3794-3 | GASKET |
| 38 | 38 | 38 | 38 | ALS4-1032-225 | INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225) |
| 34 | 34 | 34 | 34 | AN3C5A | BOLT |
| 4 | 4 | 4 | 4 | AN3C6A | BOLT |
| 4 | 4 | 4 | 4 | AN6C44A | BOLT |
| 1 | 1 | 1 | 1 | AN8C35A | BOLT |
| 38 | 38 | 38 | 38 | AN960C10L | WASHER |
| 1 | 1 | 1 | 1 | AN960C816L | WASHER |
| 4 | 4 | 4 | 4 | MS21043-6 | NUT |
| 1 | 1 | 1 | 1 | MS21083C8 | NUT |
| 4 | 4 | 4 | 4 | NAS1515H3L | WASHER |

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/2-3/4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
- POWDER COATING WITH MEK DEGREASER
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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| | | | |
|------------|---|----|----------|
| F | INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043 | PH | 08.07.16 |
| E | CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8 | CB | 07.05.17 |
| D | ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157 | PH | 06.01.05 |
| C | ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740 | CP | 98.11.18 |
| B | CHANGE MS24694-S293 TO AN8-16A | CP | 98.09.01 |
| A | NEW ISSUE | DS | 98.04.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 08.07.16 | | |

DART AEROSPACE USA, INC.

PORT HADLOCK, WA

DRAWING NO.

D2750

REV. F

SHEET 1 OF 11

TITLE

350 SKIDTUBE ASSEMBLY

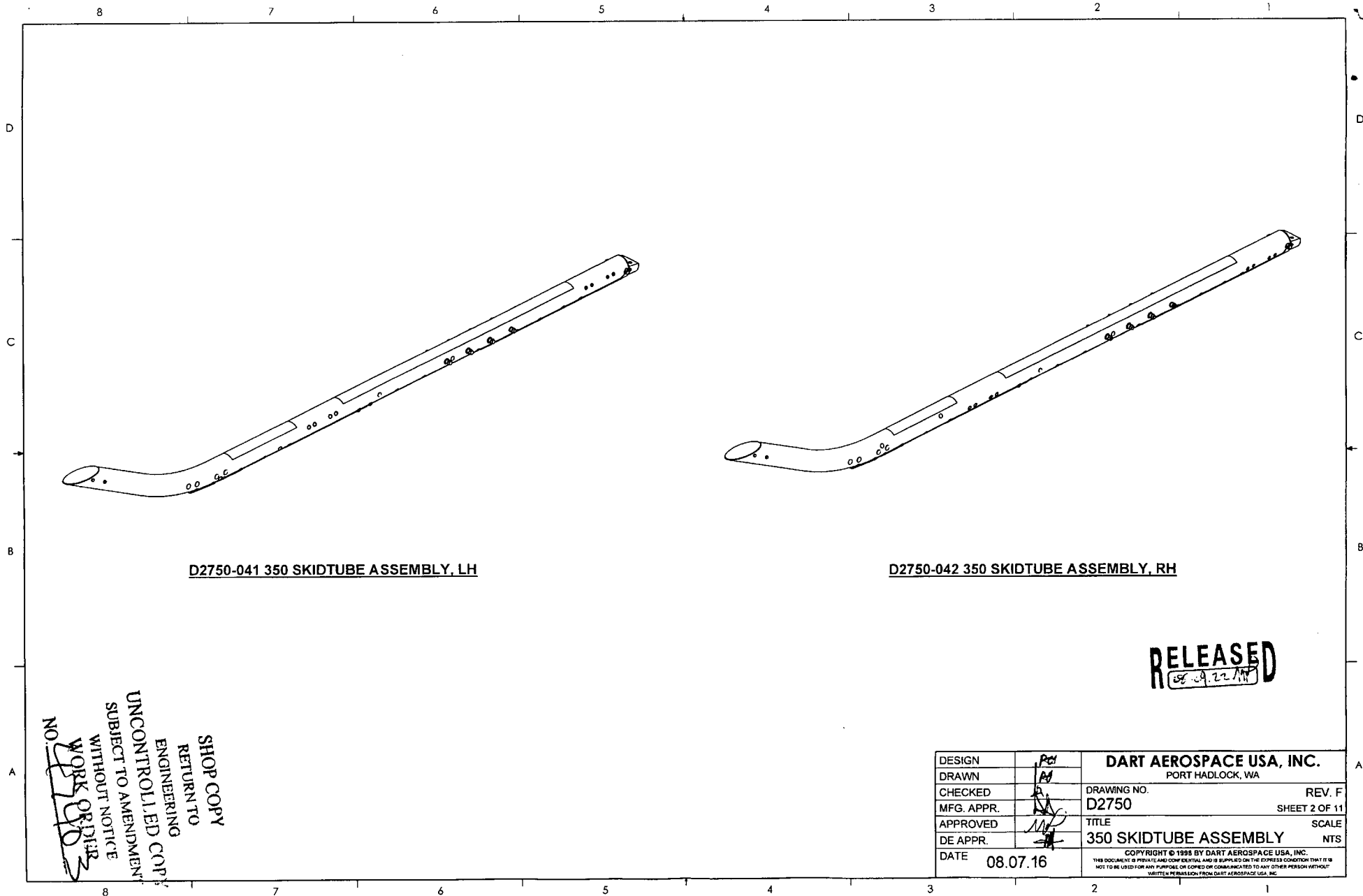
SCALE

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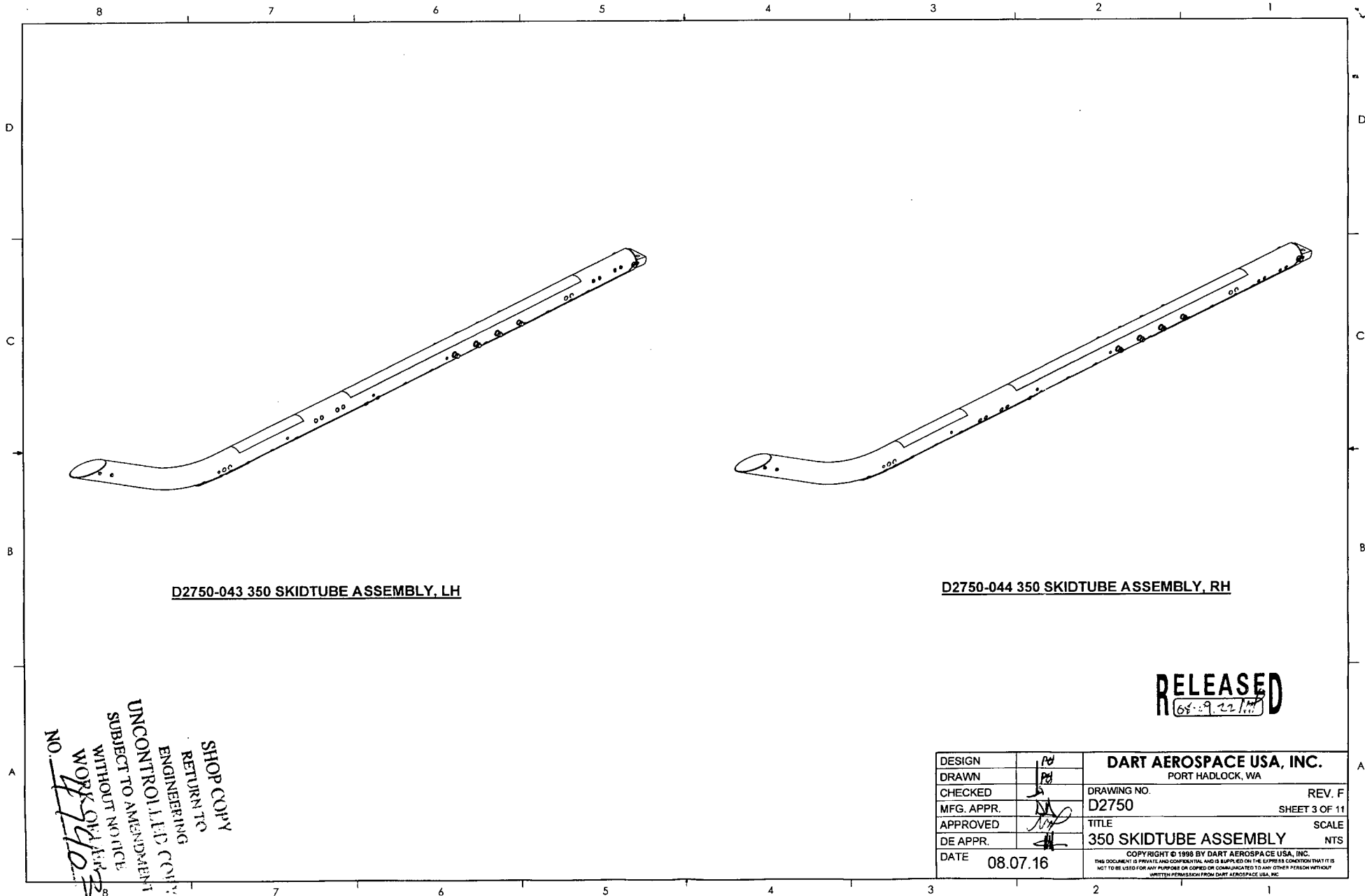
D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

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88-09-22/11

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D2750-043 350 SKIDTUBE ASSEMBLY, LH

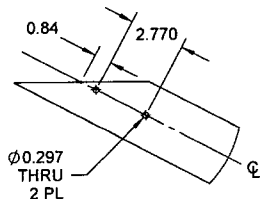
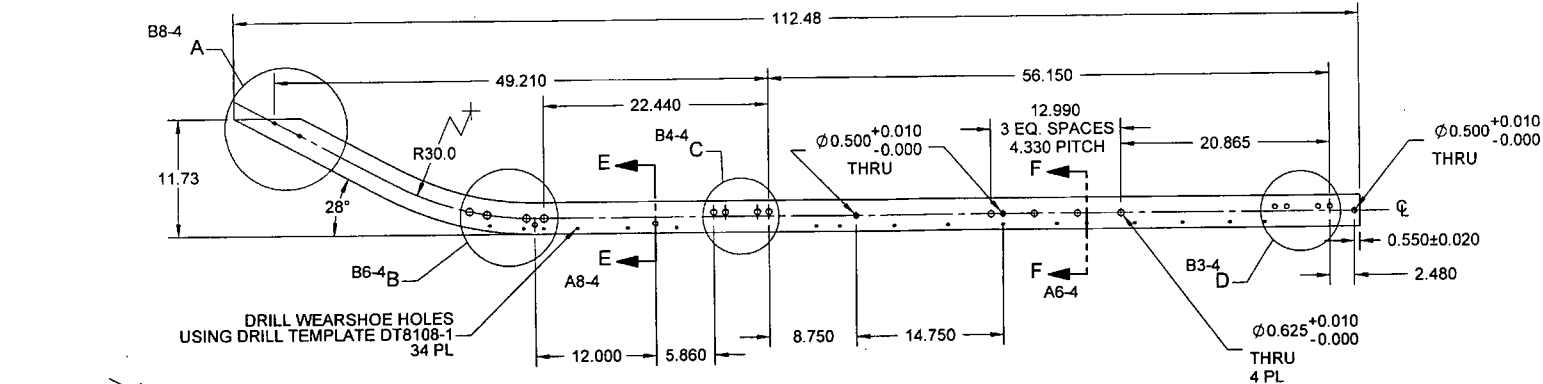
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68-9-22-1-1

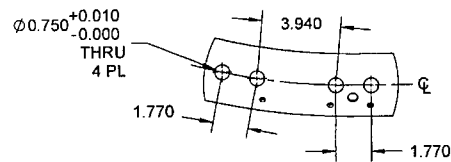
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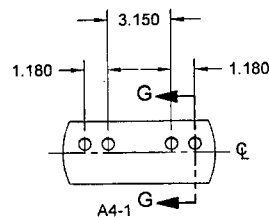
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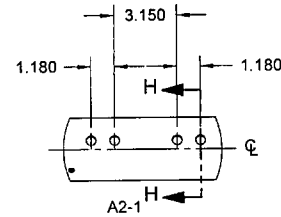
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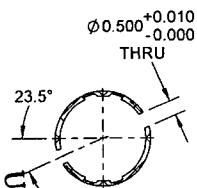
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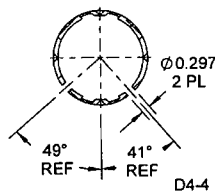
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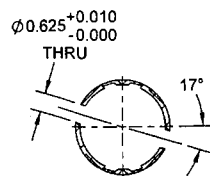
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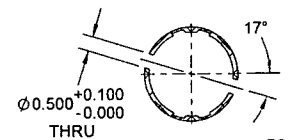
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SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

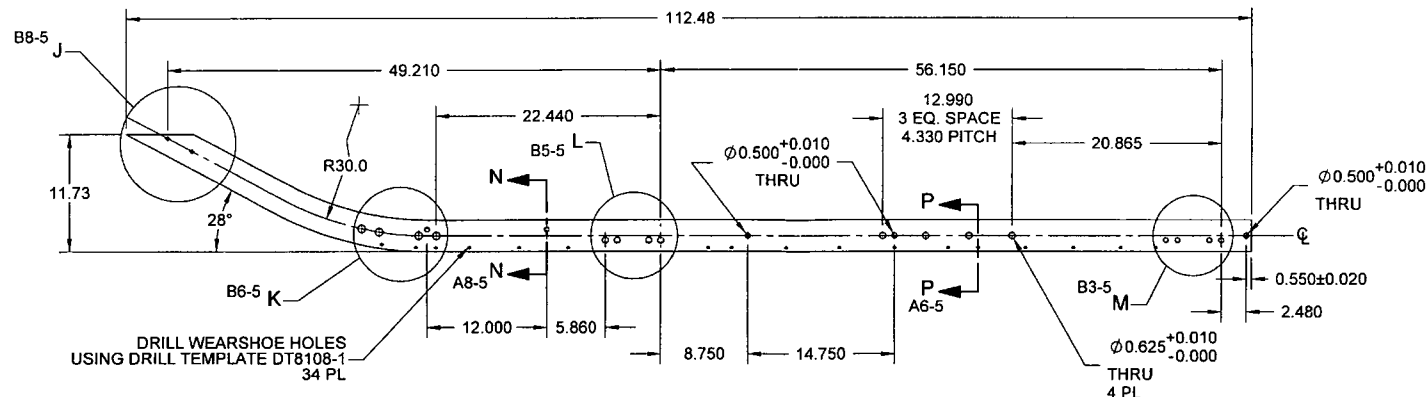


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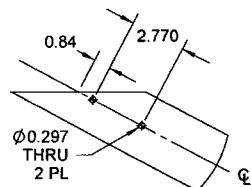
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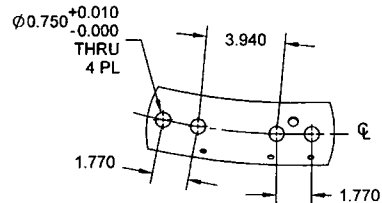
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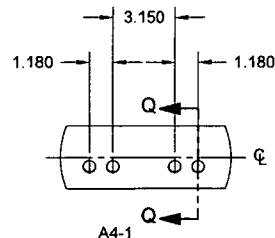
D2750-2 RH SKIDTUBE



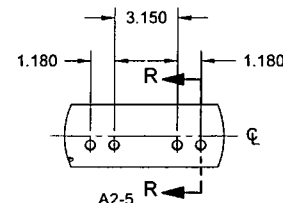
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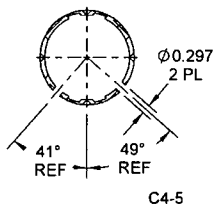
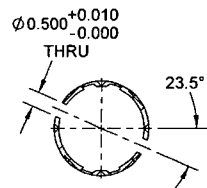
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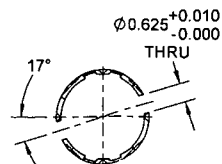
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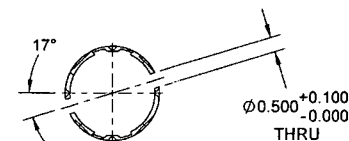
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SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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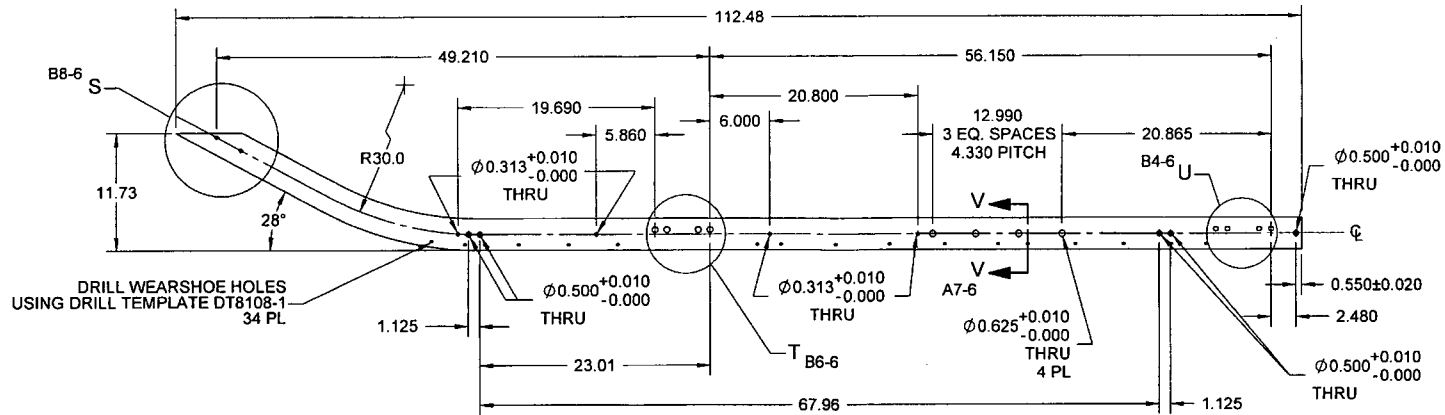
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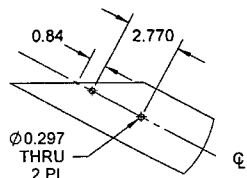
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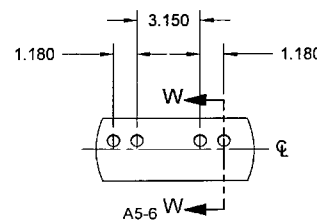
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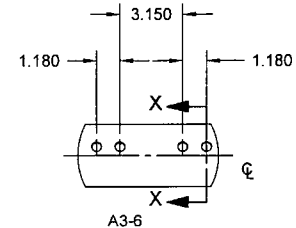
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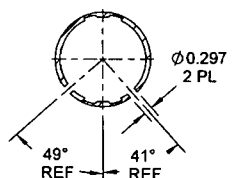
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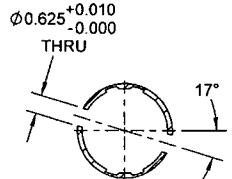
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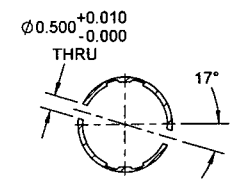
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SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



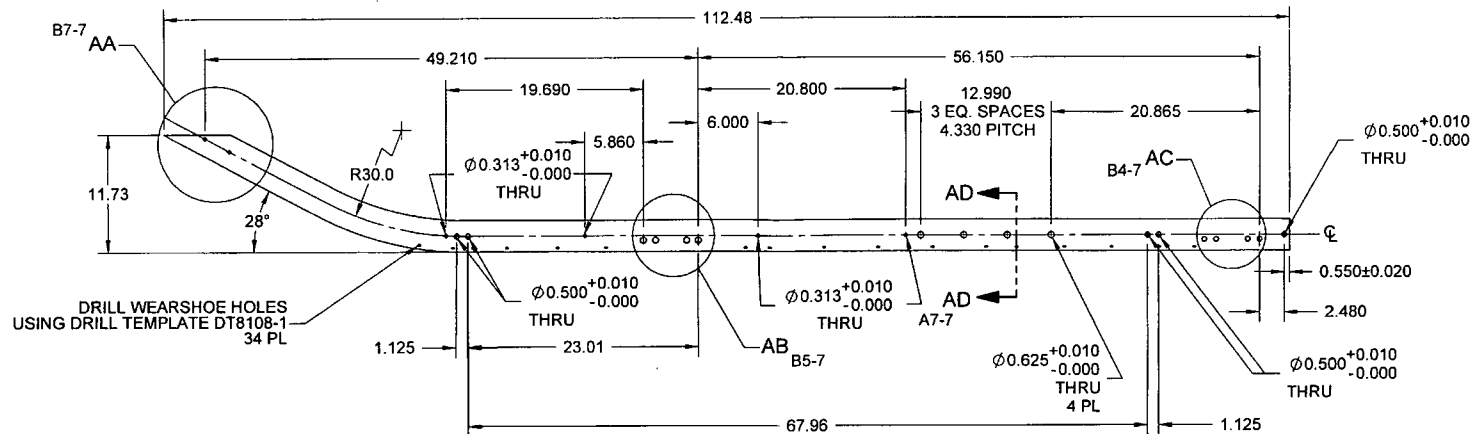
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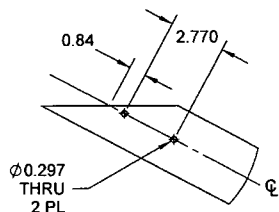
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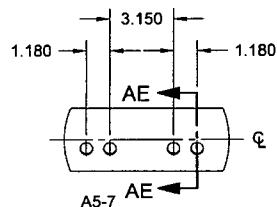
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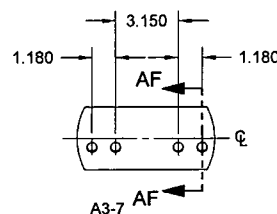
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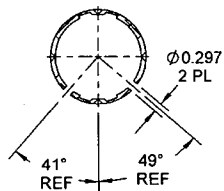
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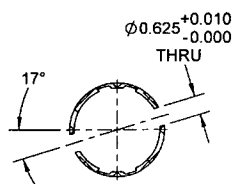
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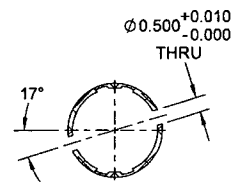
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SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



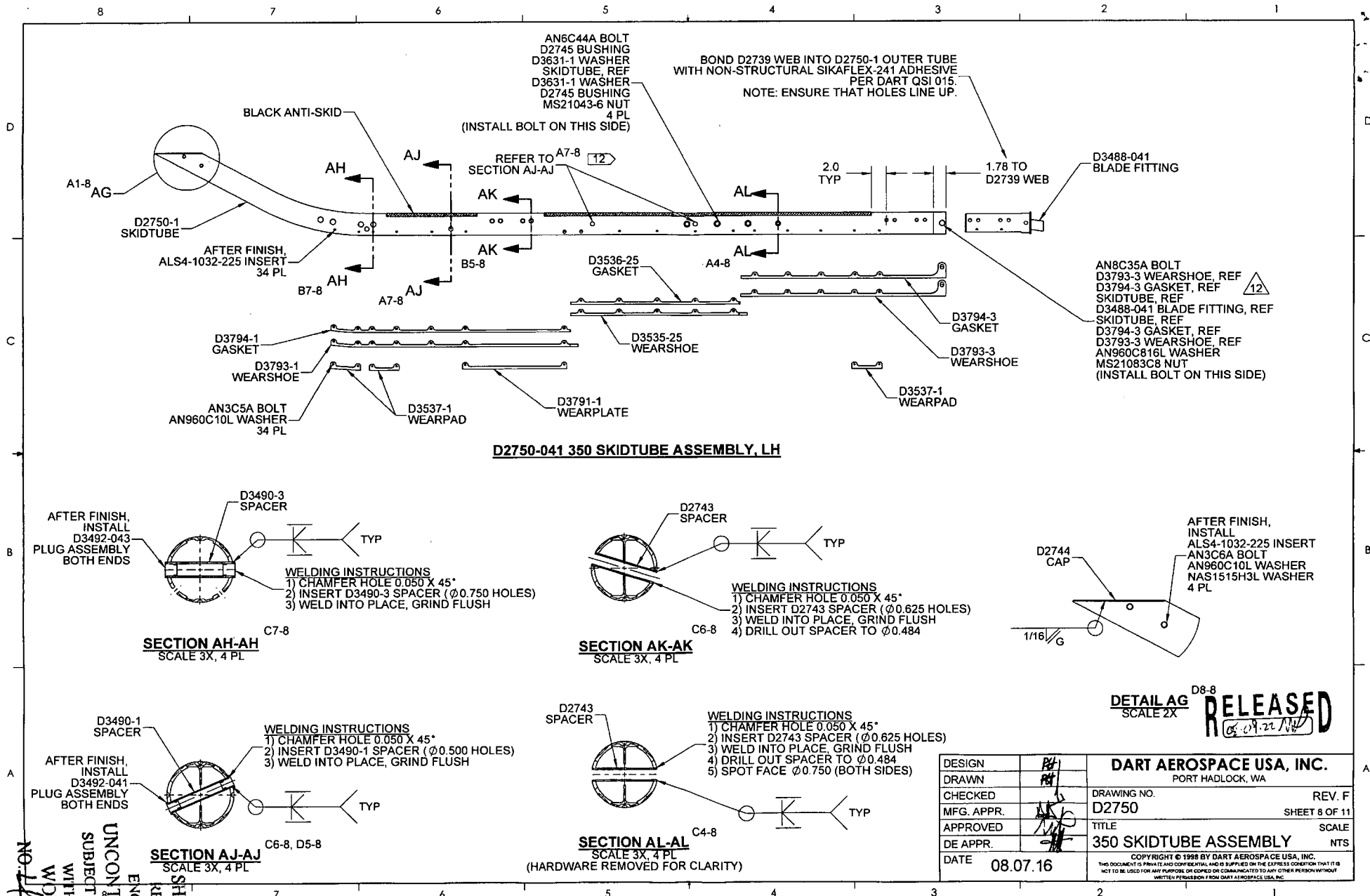
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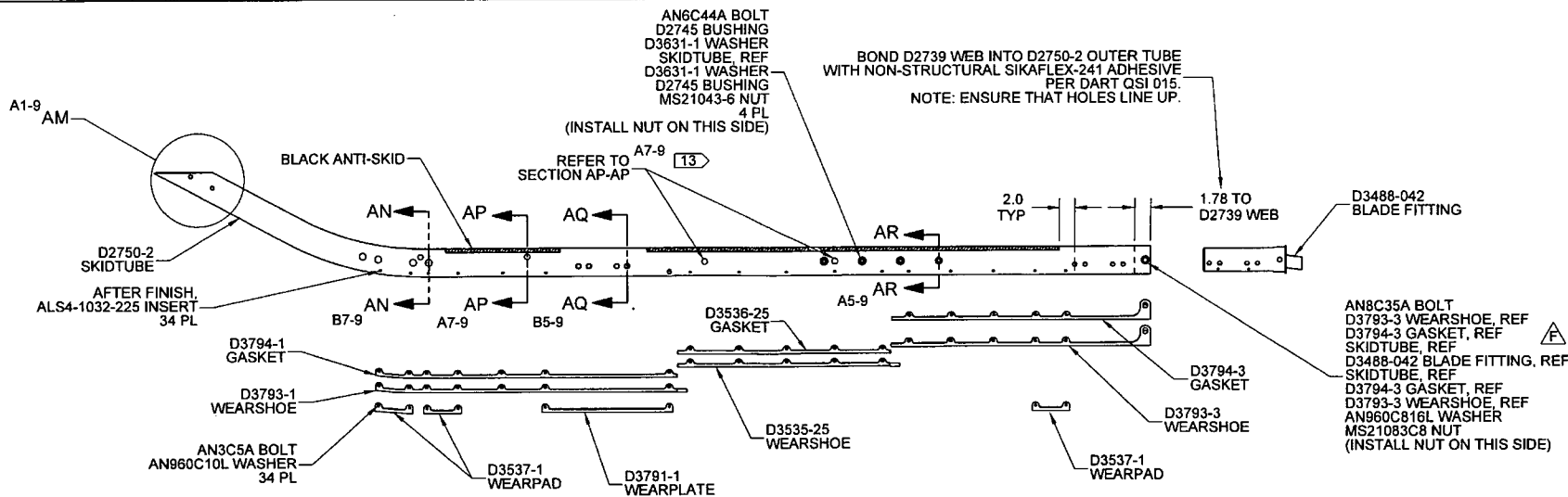
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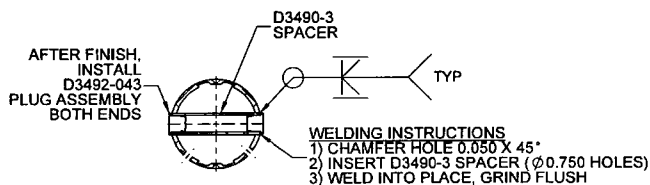
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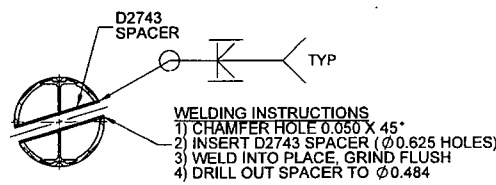
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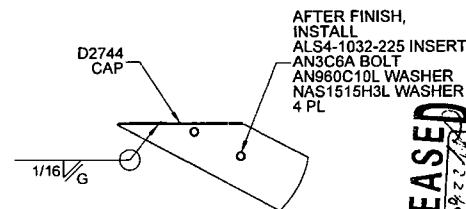
D2750-042 350 SKIDTUBE ASSEMBLY, RH



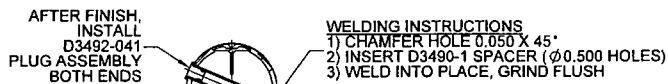
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SCALE 3X, 4 PL



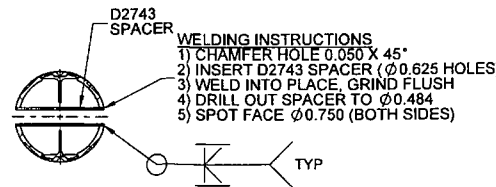
SECTION AQ-AQ
SCALE 3X, 4 PL



DETAIL AM
SCALE 2X



SECTION AP-AP
SCALE 3X, 4 PL

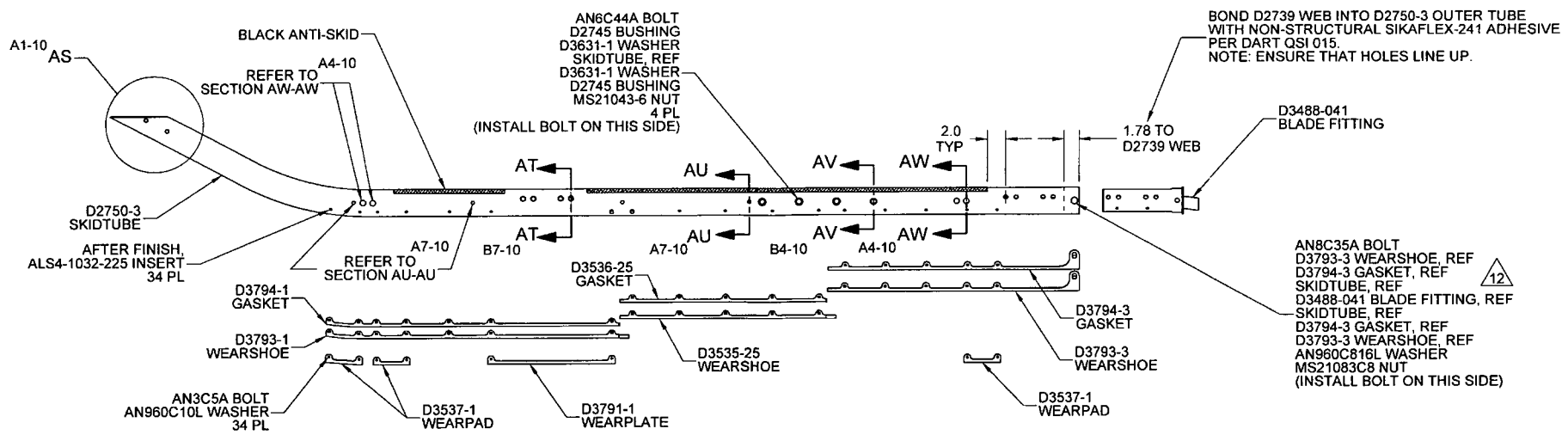


SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

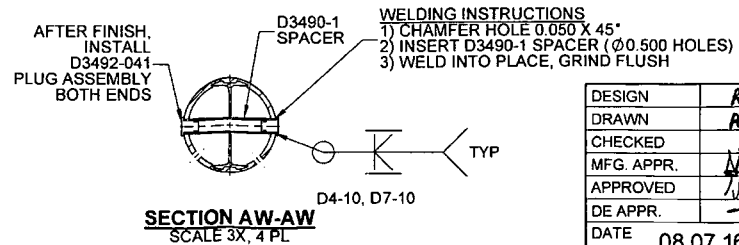
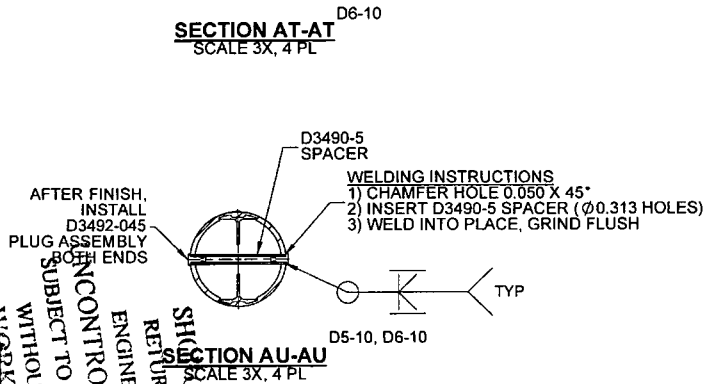
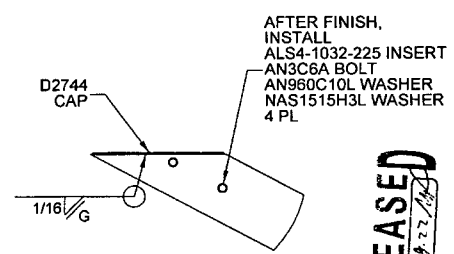
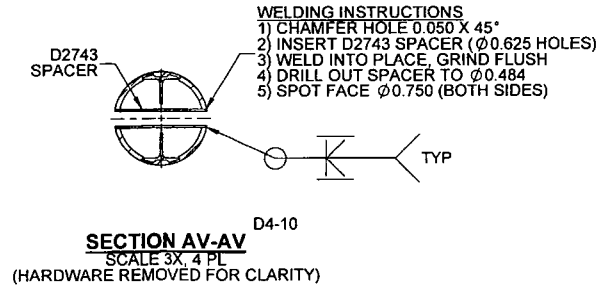
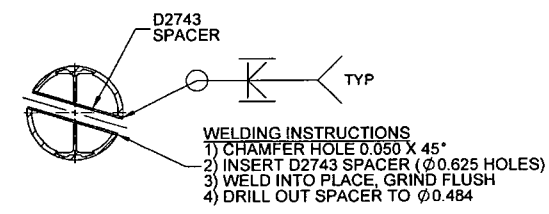
| | | | |
|------------|----------|---|---------------|
| DESIGN | PH | DART AEROSPACE USA, INC. | |
| DRAWN | PH | PORT HADLOCK, WA | |
| CHECKED | PH | DRAWING NO. | REV. F |
| MFG. APPR. | PH | D2750 | SHEET 9 OF 11 |
| APPROVED | PH | TITLE | SCALE |
| DE APPR. | PH | 350 SKIDTUBE ASSEMBLY | NTS |
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D2750-043 350 SKIDTUBE ASSEMBLY, LH

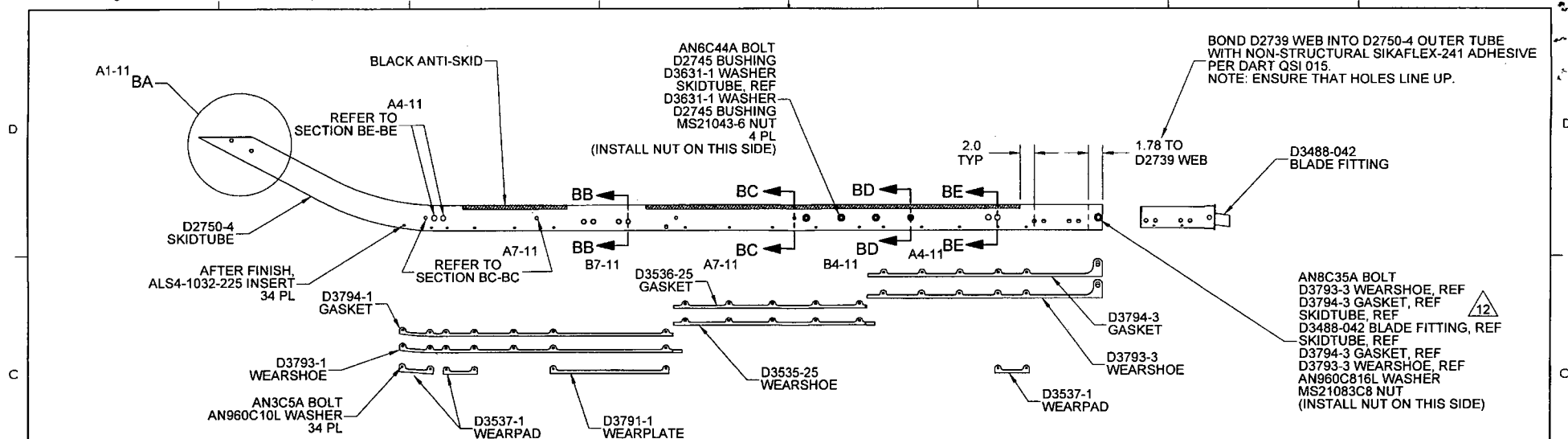


| | | | |
|------------|-----------|--|----------------|
| DESIGN | <i>18</i> | DART AEROSPACE USA, INC. | |
| DRAWN | <i>18</i> | PORT HADLOCK, WA | |
| CHECKED | <i>18</i> | DRAWING NO. | REV. F |
| MFG. APPR. | <i>18</i> | D2750 | SHEET 10 OF 11 |
| APPROVED | <i>18</i> | TITLE | SCALE |
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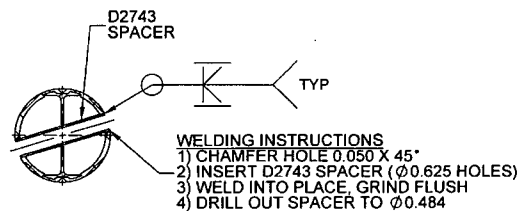
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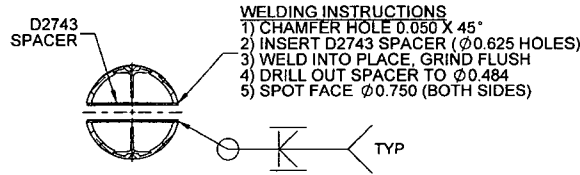
8 7 6 5 4 3 2 1



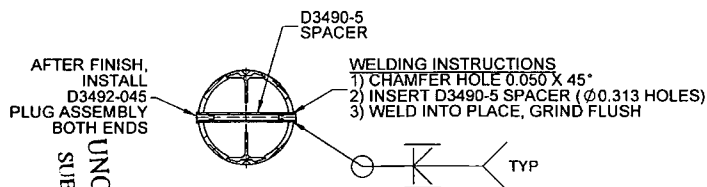
D2750-044 350 SKIDTUBE ASSEMBLY, RH



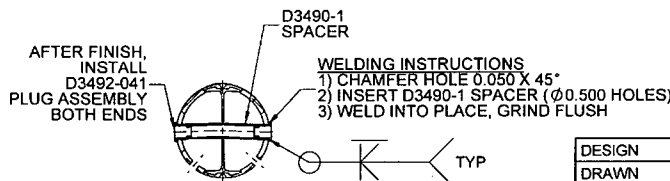
SECTION BB-BB
SCALE 3X, 4 PL



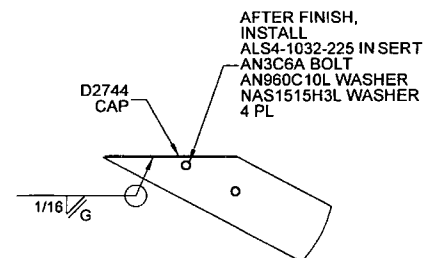
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

RELEASED

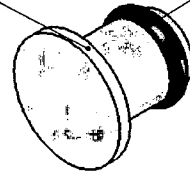
AFTER FINISH,
INSTALL
ALS4-1032-225 IN SERT
AN3C6A BOLT
AN960C10L WASHER
NAS1515H3L WASHER
4 PL

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| MFG. APPR. | 47403 | D2750 | SHEET 11 OF 11 |
| APPROVED | 47403 | TITLE | SCALE |
| DE APPR. | 47403 | 350 SKIDTUBE ASSEMBLY | NTS |
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D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

| QTY -041 | QTY -043 | QTY -045 | QTY -047 | QTY -049 | QTY -051 | QTY -053 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|
| X | | | | | | | D3492-041 | PLUG ASSEMBLY |
| | X | | | | | | D3492-043 | PLUG ASSEMBLY |
| | | X | | | | | D3492-045 | PLUG ASSEMBLY |
| | | | X | | | | D3492-047 | PLUG ASSEMBLY |
| | | | | X | | | D3492-049 | PLUG ASSEMBLY |
| | | | | | X | | D3492-051 | PLUG ASSEMBLY |
| | | | | | | X | D3492-053 | PLUG ASSEMBLY |
| 1 | | | | | | | D3492-1 | PLUG |
| | 1 | | | | | | D3492-3 | PLUG |
| | | 1 | | | | | D3492-5 | PLUG |
| | | | 1 | | | | D3492-7 | PLUG |
| | | | | 1 | | | D3492-9 | PLUG |
| | | | | | 1 | | D3492-11 | PLUG |
| | | | | | | 1 | D3492-13 | PLUG |
| | | 1 | | | | | NAS1611-005 | O-RING |
| | | | 1 | | | | NAS1611-007 | O-RING |
| 1 | | | | | | | NAS1611-010 | O-RING |
| | | | | | | 1 | NAS1611-012 | O-RING |
| | 1 | | | | | | NAS1611-013 | O-RING |
| | | | | | 1 | | NAS1611-015 | O-RING |
| | | | | 1 | | | NAS1611-016 | O-RING |



NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

~~UNDER REVIEW~~
07.04.21
OK JSS 08.11.12

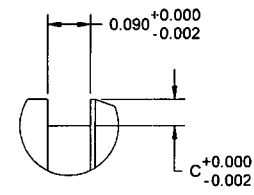
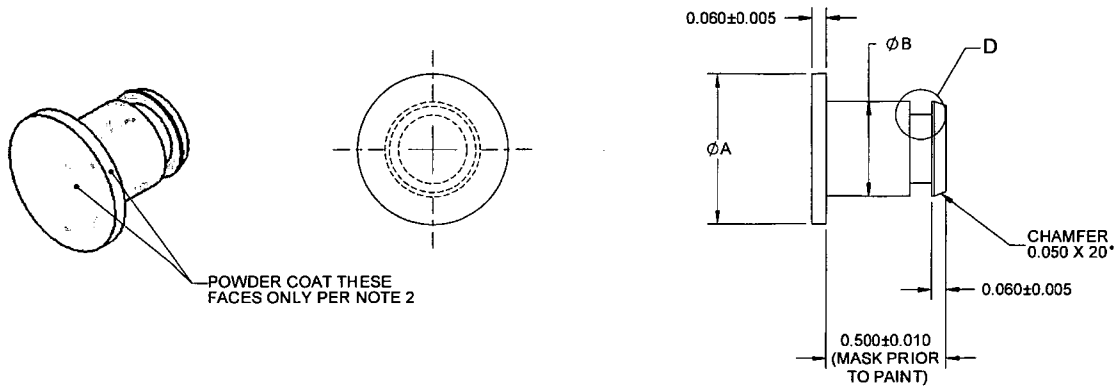
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07.10.16

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| | | | |
|--|---|--------------|----------|
| C | ADD -049/-051/-053, CHANGE DRAWING FORMAT | PH | 07.10.05 |
| B | ADD -047; UPDATE DIM A FOR -045 | PH | 06.05.11 |
| A | NEW ISSUE | PH | 06.01.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 07.10.05 | | |
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | REV. C | |
| DRAWING NO. D3492 | | SHEET 1 OF 2 | |
| TITLE PLUG | | SCALE 2:1 | |
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8 7 6 5 4 3 2 1



DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

| P/N | A | B | C | MATERIAL SPEC |
|----------|-------|-------|-------|---------------|
| D3492-1 | 0.625 | 0.394 | 0.055 | M6061T6R0.625 |
| D3492-3 | 0.750 | 0.582 | 0.045 | M6061T6R0.750 |
| D3492-5 | 0.375 | 0.188 | 0.045 | M6061T6R0.375 |
| D3492-7 | 0.500 | 0.270 | 0.045 | M6061T6R0.500 |
| D3492-9 | 0.938 | 0.750 | 0.045 | M6061T6R1.000 |
| D3492-11 | 0.850 | 0.664 | 0.045 | M6061T6R0.875 |
| D3492-13 | 0.750 | 0.520 | 0.045 | M6061T6R0.750 |

- NOTES:
- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

UNDER REVIEW
01.03.11
05M 10 ON D3492-13
REF. CK (HIRE SHAW)
13508.11.12
OK

DEO ATTACHED
RELEASED
07.11.16

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| DRAWN | | | |
| CHECKED | | | DRAWING NO. REV. C |
| MFG. APPR. | | | D3492 SHEET 2 OF 2 |
| APPROVED | | | TITLE SCALE |
| DE APPR. | | PLUG 4:1 | |
| DATE | 07.10.05 | | |

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8 7 6 5 4 3 2 1

| | | | | | | | |
|----------------------|------------------|------------------|---|--------------------|-------------------------|---------------------------|--------------|
| DRAWING NO. D3492 | TITLE PLUG | REV. C | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D3492-C-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN AJS | | CHECKED | MFG. APPR. <i>EA</i> | APPROVED <i>MD</i> | DE APPR. <i>MD</i> | | |
| DATE 08.11.05 | DATE 08.11.05 | DATE 08.11.05 | DATE 08.11.05 | DATE 08/11/05 | DATE 08/11/05 | | |

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

D3492-XX PLUG MACHINING DETAILS

| P/N | A | B | C | MATERIAL SPEC |
|----------|-------|-------|-------|---------------|
| D3492-13 | 0.750 | 0.510 | 0.045 | M6061T6R0.750 |

WAS:

D3492-XX PLUG MACHINING DETAILS

| P/N | A | B | C | MATERIAL SPEC |
|----------|-------|-------|-------|---------------|
| D3492-13 | 0.750 | 0.520 | 0.045 | M6061T6R0.750 |

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08/11/05

NO. 197

**AWS D17.1.2001
QUALIFICATION TEST RECORD**

Name: Barday Elliott
Job number: 47399
Part number: D350 636 012
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P. J. Dault Date of Test Coupon 09-04-27
Welder Barday Elliott Date of Test Coupon 09-04-27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld